

Date: Thursday, 3/13/2008 10:19:38 AM
 *User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 37925C		
Estimate Number	: 10356		
P.O. Number	:	Part Number	: D2279
This Issue	: 3/13/2008 S.O. No. :	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 37452C	Material	:
Written By	:	Due Date	: 3/28/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JB 080313</u>		
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.5435 sf(s)

Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick

(M2024T3S.040)

Identify as D2279 **MAT NOT REMOVED**Batch: 107461 **JB 8-3-25**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D 2279

Dwg Rev: D **JB 8-3-25**Prog Rev: D2-Deburr if necessary **JB 8-3-25**

(19)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JB 8-3-25

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JB 08/03/25

(19)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form As per Dwg D2279

JB 08/03/27

(19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:38 AM
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Drawing Name: STEP SPACER

Job Number: 37925C

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/27 (19)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/03/27 (19)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-27 (19)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 54112

08/3/28 19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

Job Completion



MF 08-03-28

W

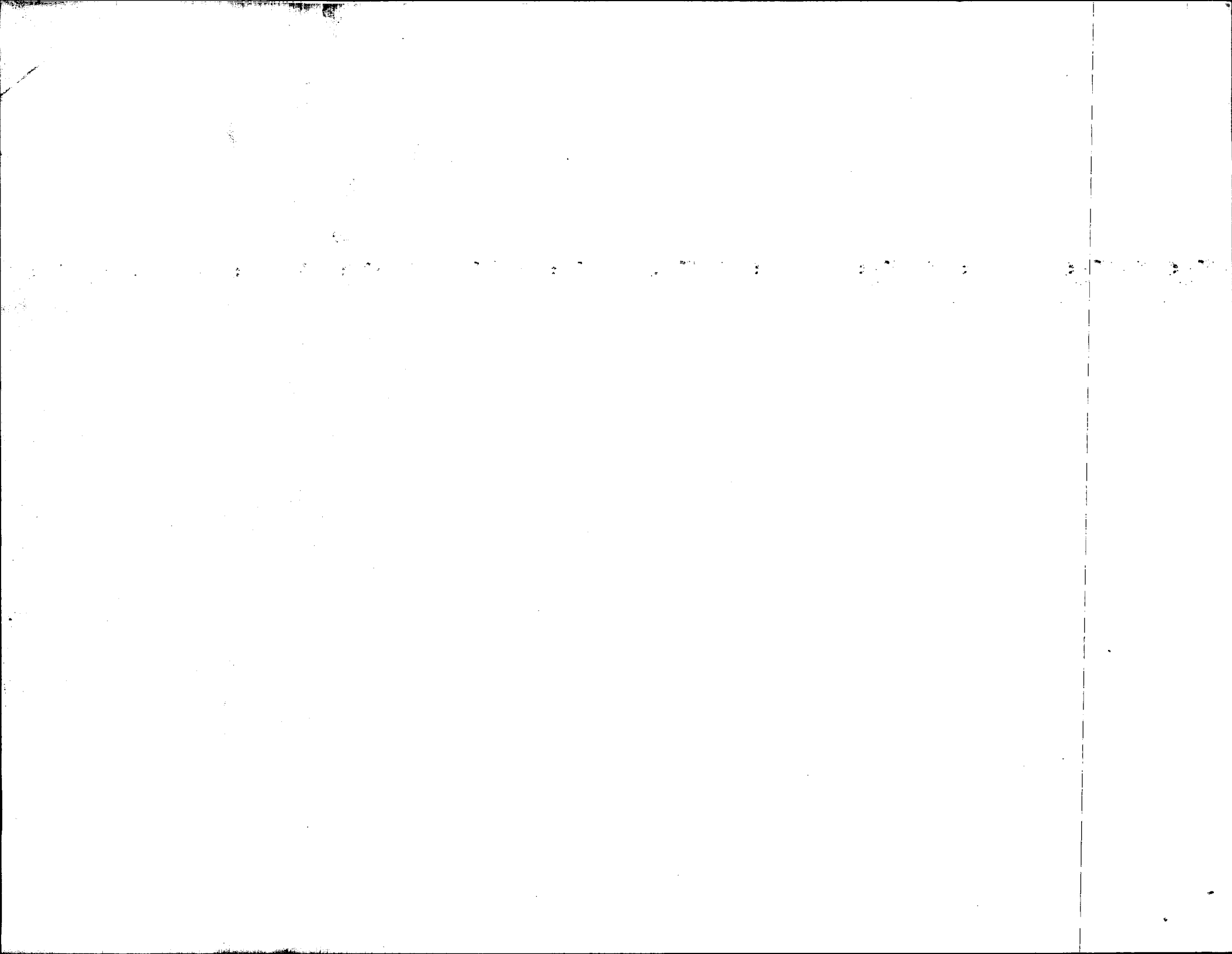
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

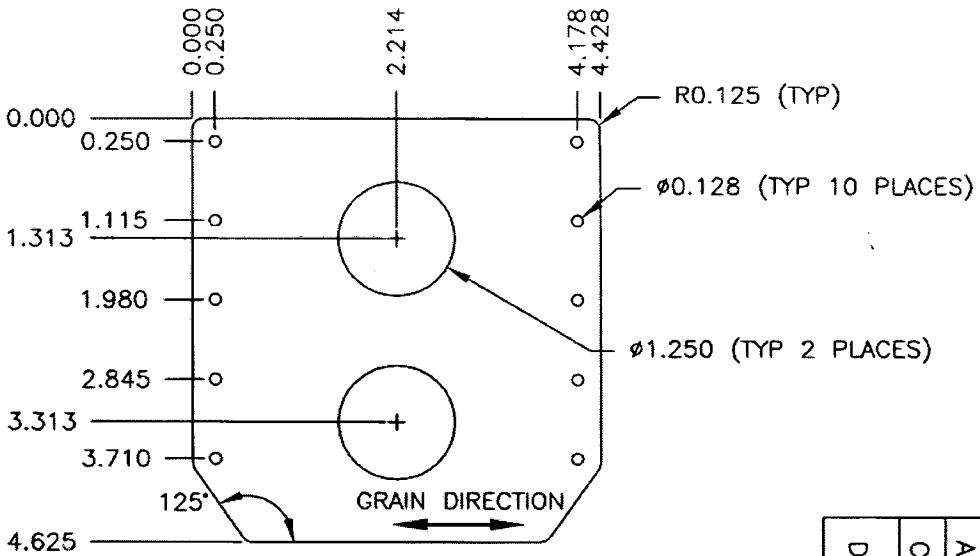
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

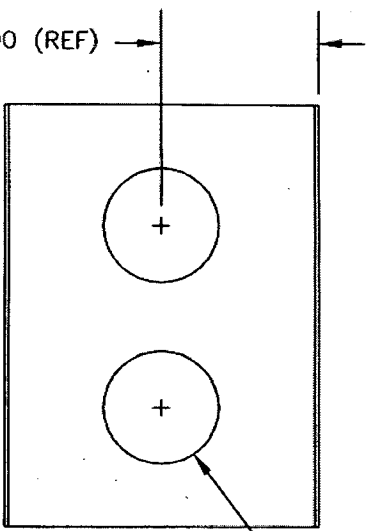




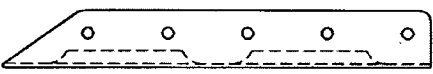
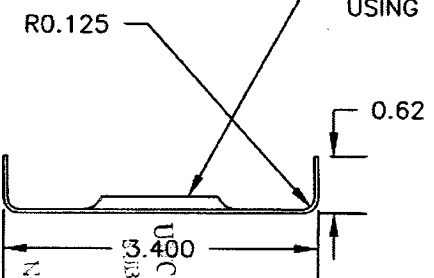
DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		JP		HAMKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	JP	DRAWING NO.	REV. D
DATE		TITLE		SHEET 1 OF 1	
98.10.05		STEP SPACER		SCALE	
A		94.10.13		NEW ISSUE	
C		94.11.15		0.588 WAS 1.607 AND 3.861 WAS 4.881	
D		98.10.05		4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



FLAT LAYOUT



FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



RELEASED
98.10.08 DS

UNDER REVIEW

OK 09/11/99
DESIGN OK, BUT CHECK WITH
TS BEFORE MANUFACTURE

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
DEPARTMENT
SUBJECT TO APPROVAL
BY
379252